

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014788**Date Inspected:** 11-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Giang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bay 9, Bay 12**Summary of Items Observed:**

Bay 9

Welding of Continuity plates on DP3087 – 001 and DP3093 – 001

This QA Inspector observed ZPMC welding personals identified as 062259 performing Flux Cored Arc welding (FCAW) on DP3093-001 U-rib internal stiffeners. ZPMC QC is identified as Yang Bai Giang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133 and WPS – B – T – 2233 – Tc – U4b – F (CJP)

This QA Inspector observed ZPMC welding personals identified as 059403 performing Flux Cored Arc welding (FCAW) on DP3087-001 U-rib internal stiffeners. ZPMC QC is identified as Yang Bai Giang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133 and WPS – B – T – 2233 – Tc – U4b – F (CJP)

Tack Welding

This QA Inspector observed ZPMC welding personals identified as 062305 and 059472 performing Gas Metal Arc welding (GMAW) tack welding on DP3146-001 (PL 3342A, PL 3342B, PL 3342C) deck plate to U-rib. ZPMC QC is identified as Yang Bai Giang. The welding variables recorded by QC appeared to comply with the WPS-345-B-T-2342 U5b (U-Rib).

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Gantry Welding

No Gantry welding was being performed on this day.

Bay 12

No relevant work noted

This QA Inspector randomly walked Bay 9 and Bay 12 throughout the shift duration.

QA Inspector updated East End tack weld assessment summary spreadsheet.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
